

Work Order ID 63678

November 10, 2010 7:45:08 AM

Page 1

Item ID: D212-725-1-011

Accept

Setup Start

Revision ID:

Stop

Item Name: Angle

Start Date: 11/10/10 Start Qty: 2.00

Cust Item ID:

Required Date: 11/12/10 Req'd Qty: 2.00

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D212-725-1

Rev B

100

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut as per dwg

2-Make radius as pre dwg and deburr

=> m.l 10/11/12

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Siduliz

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

=> Hl 10/11/12

2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

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Tooling:

Date:

QC:

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Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

D BR 10-11-12

140

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

CC 11/12 (2)

150

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/11/12

10-11-12 (2)

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

November 10, 2010 10:43:45 AM

Page 1

Work Order ID: 63678

Parent Item: D212-725-1-011

Parent Item Name: Angle



Start Date: 11/10/10

Required Date: 11/12/10

Start Qty: 2.00

Required Qty: 2.00

Comments:

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M2024T3A1.0X1.0X12 5	AA	Purchased	No				f	12.0000		0.2125			



Angle 2024T3511 1.0x1.0x.125w

AA

Location

MAT

116085

Loc Qty

12

12

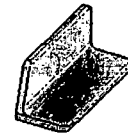
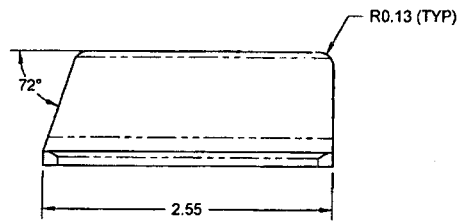
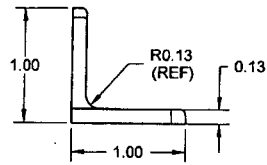
Loc Code



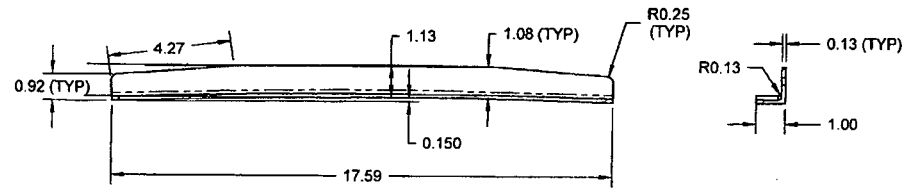
m-f 10/11/11

0.2125

01013678



D212-725-1-011 ANGLE
D212-725-1-012 OPPOSITE
 SCALE 1:1



D212-725-1-015 STIFFENER ANGLE
 SCALE 1:8

D212-725-1-011/-012/-015 NOTES:

- 1) MATERIAL: 2024-T3511 (QQ-A-200/3F) ANGLE EXTRUSION
- 2) FINISH: ACID ETCH, ALODINE 1200 OR 1201 PER MIL-C-5541 AND/OR PRIME & PAINT PER AIRCRAFT MAINTENANCE MANUAL
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFY WITH DART P/N USING FINE POINT PERMANENT INK MARKER

RELEASE
 2009-10-28
 JND

DESIGN DC	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED DS	APPROVED <i>[Signature]</i>	DRAWING NO. D212-725-1	REV. D SHEET 5 OF 67
DATE 08.03.14		TITLE 212S DETAIL PARTS	SCALE 1:2
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